

Date: Tuesday, 23/12/2008 1:23:11 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DECAL
<b>Job Number</b> : 44306	
<b>Estimate Number</b> : 11164	
<b>P.O. Number</b> :	<b>Part Number</b> : D32763
<b>This Issue</b> : 23/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3276 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 36633	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/01/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est A 05/02/14 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 7886

For D3276-3 decal as per Dwg D3276

Possible Supplier: Studio Lettrage

Material release note is required

C 208112123

(20)

2.0	D32763P	Decal
-----	---------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 20.0000 Each(s)  
 Decal

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

P 2081231 (20)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

S 02/01/05 (x20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 5T80

09/01/05 (x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/12/2008 1:23:11 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECAL

Job Number: 44306

Part Number: D32763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

MF 09/01/06

Job Completion



MF 09-01-05

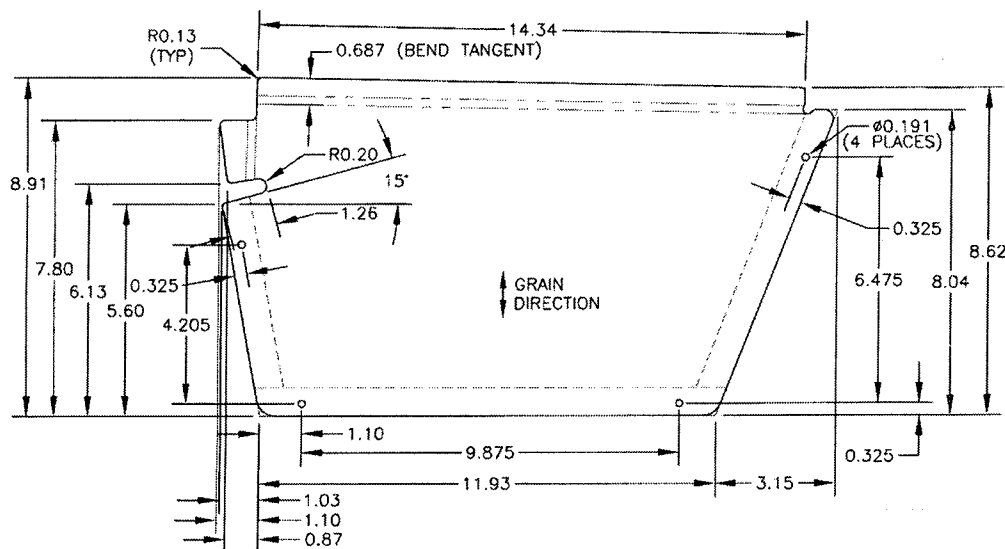
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

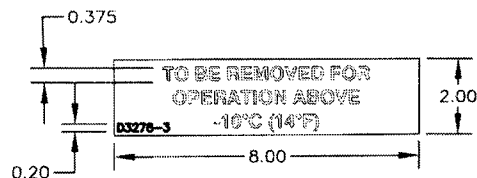
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



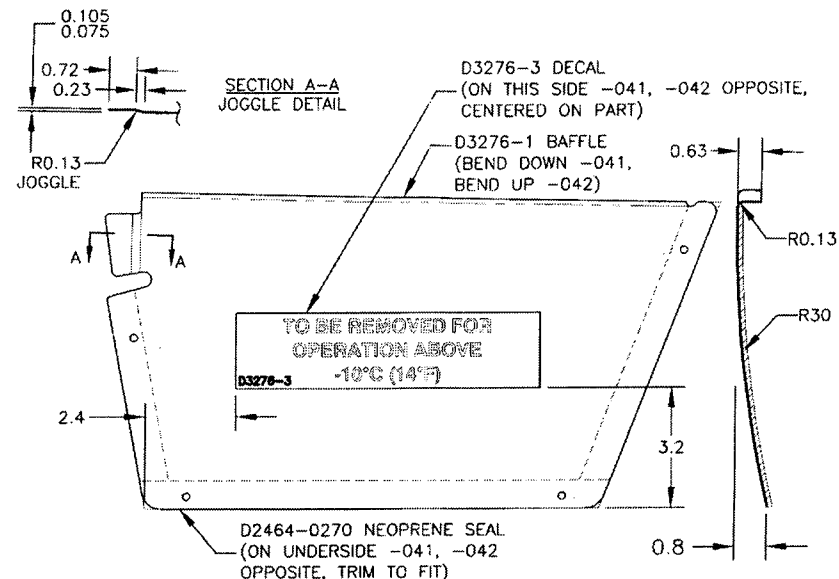
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

*Don't know*

RELEASED  
CS 02 00

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	✓	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY

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**DART** DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. D3276  
REV. B  
SHEET 1 OF 1  
SCALE 1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Scotchcal™

## Opaque Imaging Media 8522

### Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

### Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlamine can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

### Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

### Product Bulletin 8522

Release F, Effective January 2003  
Black bar in margin indicates a change

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

### Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

### Compatible Products and Equipment

#### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

#### Overlaminates (required)


- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

## Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
  - Original packaging, including plastic wrap
  - Relative humidity of 20% to 80%
  - Temperature of 33° to 104°F (0° to 40°C)
  - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

## Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

## Warranty and Limited Remedies

### 3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

*The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These*

### 3M

#### Commercial Graphics Division

3M Center, Building 220-6W-06  
PO Box 33220  
St. Paul, MN 55133-3220 USA  
General Info. 1-800-374-6772  
Technical Info. 1-800-328-3908  
Fax 1-651-736-4233

Fax-on-Demand 1-800-364-0768 U.S./Canada or 1-651-732-6506 International  
Fax-on-Demand document: 4506  
[www.scotchprint.com](http://www.scotchprint.com)

#### 3M Canada

P.O. Box 5757  
London, Ontario  
Canada N6A 4T1  
1-800-265-1840  
Fax 519-452-6245

#### 3M México, S.A. de C.V.

Av. Santa Fe No. 55  
Col. Santa Fe, Del. Álvaro Obregón  
México, D.F. 01210  
52-55-52-70-04-00  
Fax 52-55-52-70-22-77

#### 3M Puerto Rico, Inc.

Puerto Rico Industrial Park  
P.O. Box 100  
Carolina, PR 00986-0100  
787-620-3000  
Fax 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

## 3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at [www.scotchprint.com](http://www.scotchprint.com), or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768  
International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
<b>Product Bulletins</b>		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
<b>Instruction Bulletins</b>		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
<b>Warranties</b>		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

*3M, Scotchcal and MCS are trademarks of 3M.  
Epson and Stylus Pro are trademarks of Epson.  
HP and DesignJet are tradenames of Hewlett Packard.  
Sintra is a trademark of Swiss Aluminum Ltd.  
Intron is a registered trademark of DuPont in the United States*

## Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.



**210 MAIN ST. W.,  
HAWKESBURY, ONT. K6A 2H6  
Tel.: 613 632-5449  
Fax: 613 632-9491  
[www.studiolettrage.on.ca](http://www.studiolettrage.on.ca)**

**INVOICE / FACTURE**

No.: 11489  
DATE: 12/30/2008

PAGE 1 of 1

Re: Quote No. 6283

**VENDU À:**  
**SOLD TO:**

**LIVRÉ À:**  
**SHIPPED TO:**

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd  
Hawkesbury, Ontario

ITEM ARTICLE	QTY QVE	UNIT UNITE	DESCRIPTION	GST IPS	PST TVP	UNIT PRICE PRIX UNITE	AMOUNT MONTANT
	6 20 1		label D33511F set up label D32763 set up printing  E - GST @ 5% G - GST @ 5% ; PST @ 8% GST PST Exempt: 6122-5207	E E G		8.3333 2.5000 50.0000	50.00 50.00 50.00   7.50
GST /TPS: R122278690							
Studio de Lettrage GST: #869034678RP001						<b>TOTAL</b>	157

~~PO 7886~~

Sold By:

Merrell Thank You!

# DART

## Purchase Order

Date Dec 23, 2008	Page 1
Purchase Order Number PO00007886	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

*REUSED*

*FAXED*  
*12/23/08*

**Vendor Address:**

Studio de Lettrage 2001  
210 Main West  
Hawkesbury, ONT K6A 2H6  
Canada  
Phone (613) 632-5449  
Fax (613) 632-9491

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-STU001	Dec 23, 2008	N30	yours	Jan 09, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
6.0000	D33511P	Placard Comments: AS PER I VG D3351 REV. A B44247	09/01/2009	No	7.500000	Each	45.00
20.0000	D32763P	Decal Comments: AS PER I VG D3276 REV. B B44306	09/01/2009	No	5.000000	Each	100.00

CERTIFICATE OF CONFORMITY  
REQ'D UP N DELIVERY

**Comments:****Tax Summary:**

GST 7.25  
GSTME 0.00  
GSTND 0.00

Less:  
included tax

0.00

Subtotal

145.00

Total tax

7.25

Total purchase order in

CAD Dollars

152.25

Entered By: *CLAVOIE*

Approved By: \_\_\_\_\_